

Split -2.

Order ID 87469

9:54:00 AM

87469

Page 1

Item ID: D3659-1

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: CUFF

Stop ***NS2***

Start Date: 7/10/12

Start Qty: 10.00

10

Required Date: 8/10/12

Req'd Qty: 10.00

10

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *MES*

Date: *12/07/19*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3659

Rev B

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

Cut blank 7.300" long

0.00

*DAS
13
2-89*

12/8/4

16

110

110

Doosan

Doosan Lathe

DOOSAN LATHE

0.00

Memo

1-Turn as per folio FA 707 & DWG D3659,
FOLIO REV:

DWG REV: *13*

2-Deburr as required

0.00

*DAS
13
2-89*

12/8/4

4/10

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*DAS
13
2-89*

12/8/4

4/10

Work Order ID 87469***87469***

Page 2

July-19-12 9:54:00 AM

Item ID: D3659-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: CUFF

Start Date: 7/10/12

Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 10.00

10

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

Jul 12-08-22

140

Chemical Conversion Coat per QS1005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

QRG 12822

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

*42**12/8/23*

Work Order ID 87469

87469

Page 3

July-19-12 9:54:00 AM

Item ID: D3659-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: CUFF

Start Date: 7/10/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location 482	0.00		50		4	8	12/8/23	
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MCJ 12108123

ME
12.08.23

Picklist Print

July-19-12 9:53:59 AM

Page 1

Work Order ID: 87469

Parent Item: D3659-1

Parent Item Name: CUFF

Start Date: 7/10/12

Required Date: 8/10/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A new issue 07.09.19 EC verified by:JLM
IPP Rev:B 08-04-07 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6009-129 Crosstube Material		Manufactured	No			100	Each	17.0000	0.1	1.052632			

Location

Loc Qty

Loc Code

LG

17

17

6008-180

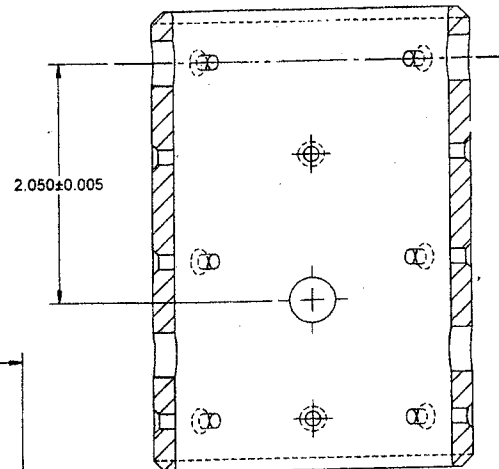
*This bucket
only. Jul 12.08.15.*

~~60801~~

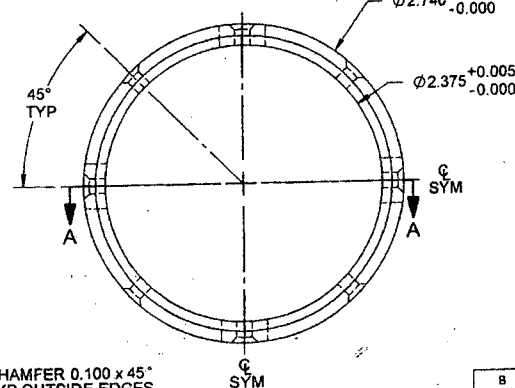
46779

D40
13
89

? At
? Blanks
? already pulled

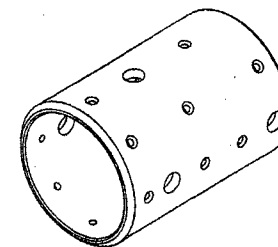


SECTION A-A
R0.032 TYP
INSIDE EDGES



CHAMFER 0.100 x 45°
TYP OUTSIDE EDGES

D3659-1 CUFF



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 07469 MLS
12/07/19

Handwritten signature/initials

DRILL #30 (Ø0.128 REF)
C/SINK Ø0.230x100°
TYP 22 PLACES



Ø0.388 +0.005
-0.000

HOLE TO BE ALIGNED
WITHIN ±0.001 OF HOLE
ON OTHER SIDE OF CUFF,
TYP 6 PLACES



NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6005, D6006, D6008, D6009, D6011, OR D6019)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.56 lbs

B	ADD Ø0.128 & Ø0.388 HOLES (B8)	CP	08.03.03
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>P</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3659 TITLE CUFF SCALE NTS	
DRAWN	<i>P</i>		
CHECKED	<i>H</i>		
MFG APPR.	<i>E</i>		
APPROVED	<i>W</i>		
DE APPR.	<i>H</i>	DATE 08.03.03 <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

